

# Work Order ID 85925

**\*85925\***

Page 1

Item ID: D2804-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bracket

Start Date: 18/06/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/18

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2804

Rev C

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per File D2804-1-2\_Blank

Dwg Rev: \_\_\_\_\_

Prog Rev: \_\_\_\_\_

2-Deburr if necessary

6061, 500 x 10.00

8 0 Jan 12-6-20

110

0.00

**\*110\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA103

PO 12/09/27

J Ø

120

0.00

**\*120\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

PO 12/09/27

8 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**NOTE:** Date & initial all entries

**\*85925\***

June-18-12 2:34:04 PM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 18/06/2012    **Start Qty:** 8.00    **\*8\***

**Cust Item ID:**

**Required Date:** 02/07/2012      **Req'd Qty:** 8.00      **\*Q\***

**Customer:**

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Identify as per dwg & Stock Location

0.00

**\*150\***

### Packaging

## Memo

0.00

## Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

8

12/10/30

MF  
12-10-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

June-18-12 2:34:08 PM

Page 1

Work Order ID: 85925

\*85925\*

Parent Item: D2804-1

\*D2804-1\*

Parent Item Name: Bracket

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A00.11.06New IssueEC  
IPP B06.05.30 Blanks on wtjetEC  
IPP Rev:C As per Rev C 06-11-09 JLM  
IPP Rev:D Removed Tumbling 08-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased	No				f	55.4000		(6)			

\*M6061T6B0 500X10 000\*

\*\*

6061-T6 Bar .500 x 10.00

JUN 12-6-20

Location

Loc Qty

Loc Code

MAT004

55.4

121660

31.3

121836

24.1

121836

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	85925
Description: Bracket		Part Number:	D2804-1
Inspection Dwg: D2804 Rev: C		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.758	✓		VERN	P40-01
Ø0.191	+0.005/-0.001	.192	✓		VERN	"
1.420	+/-0.001	1.420	✓		"	"
Ø0.507	+0.000/-0.001	.507	✓		DT 9526-E	GO-NOGO
0.250 deep	+/-0.010	.247	✓		MIC	P40-09
Ø0.507	+0.000/-0.001	.507	✓		DT 9516-E	GO-NOGO
Ø0.191	+0.005/-0.000	.192	✓		VERN	P40-01
6.933	+/-0.010	6.934	✓		"	CNC-02
7.578	+/-0.010	7.580	✓		"	"
12.304	+/-0.010	12.304	✓		H G.	
0.125	+/-0.010	.123	✓		VERN	P40-01
0.500	+/-0.010	.497	✓		"	"
0.125	+/-0.010	.130	✓		MIC	P40-02
0.250	+/-0.010	.249	✓		VERN	P40-01
0.875	+0.000/-0.001	.874	✓		MIC	P40-02
0.250	+0.000/-0.005	.246	✓		MIC	P40-09

Measured by: PO	Audited by: L.A.	Prototype Approval:	N/A
Date: 12/09/27	Date: 12/09/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.06.05	Removed dimensions 12.625, 0.608, 0.437, 2.654	KJ/EC	
C	06.11.10	Revised per drawing revision C	KJ/JLM	
D	09.03.10	Tolerance revised for Ø0.757	KJ/DD	

**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

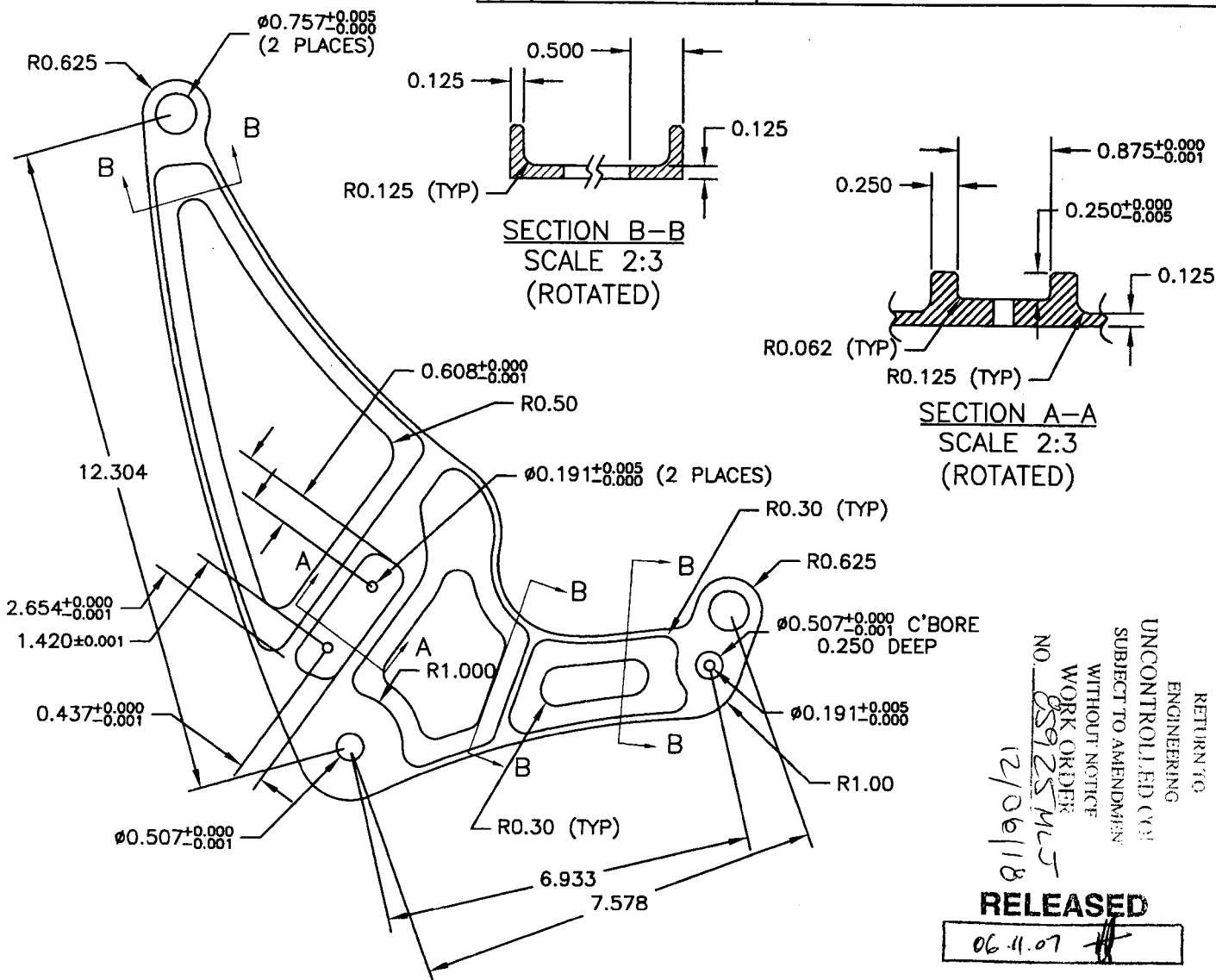
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 08925 MCT  
12/06/18

RELEASED

06.11.07

### D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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# Dart Aerospace Ltd

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

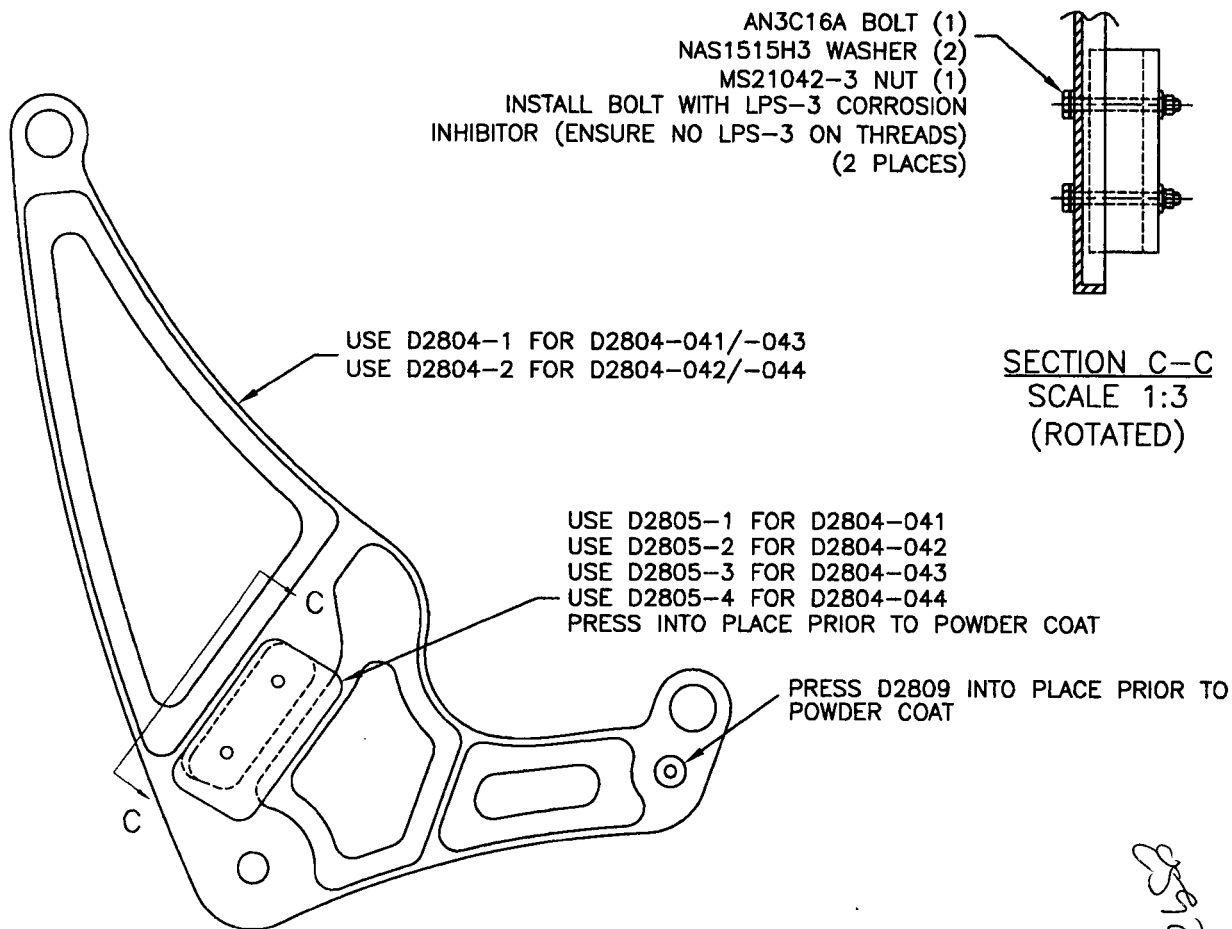
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



05625

RELEASED

06.11.07 [Signature]

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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